

Page 1

Monday, August 28, 2017 12:58:34 PM

NS1

Revision ID:

Stop *NS2*

Item Name: Wearplate Fwd

12

Cust Item ID:

12

Customer:

Reference:

Date:

Run Start *NR1*

Date: _____

Stop *NR2*

**Insp.
Stamp**

Revision Nbr

A

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

2.40

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: 4

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.12

**DAS
40
9.89**

**DAS
40
1989**

Monday, August 28, 2017 12:58:34 PM

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Fwd

12

Cust Item ID:

12

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

120

0.24

QC

Memo

Quality Control

0.43

130

0.71

Brake NC

Memo

Brake NC

FORM JOGGLE AS DWG

0.00

140

0.24

OC

Memo

Quality Control

Work Order ID 165747

165747

Page 3

Monday, August 28, 2017 12:58:34 PM

Item ID: D4956-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Fwd
Start Date: 9/28/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 10/4/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150						<u>12</u>			DAS 41 9-89
HandFinish	Memo	0.24							
Hand Finishing	1- After finish, coat entire top (concave) surface as per note 2 dwg D4956. TEXTURED COATING B#: <u>138351</u>								SEP 14 2017
160	QC3- Inspect Part Finish	0.00							
160						<u>12</u>	<u>Ø</u>		DAS 9 9-89
QC	Memo	0.12							
Quality Control									
170	Identify as per dwg & Stock Location: <u>FP002</u>	0.00							
170						<u>(X12)</u>	<u>Ø</u>		20170915 BEB
Packaging	Memo	0.12							
Packaging	LOCATION : FP002								

Work Order ID 165747***165747***

Page 4

Monday, August 28, 2017 12:58:34 PM

Item ID: D4956-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Fwd
Start Date: 9/28/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 10/4/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	1.20							
Quality Control									

DAS
21
9-89

SEP 15 2017

Picklist Print

Monday, August 28, 2017 12:58:37 PM

Page 1

Work Order ID: 165747

165747

Parent Item: D4956-11

D4956-11

Parent Item Name: Wearplate Fwd

Start Date: 9/28/2017

Required Date: 10/4/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

88.7600

0.665

8.4

M304S20GA

17/09/02

DAS
40
9-89

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

88.76

m137513

7.5

m137762

7.6

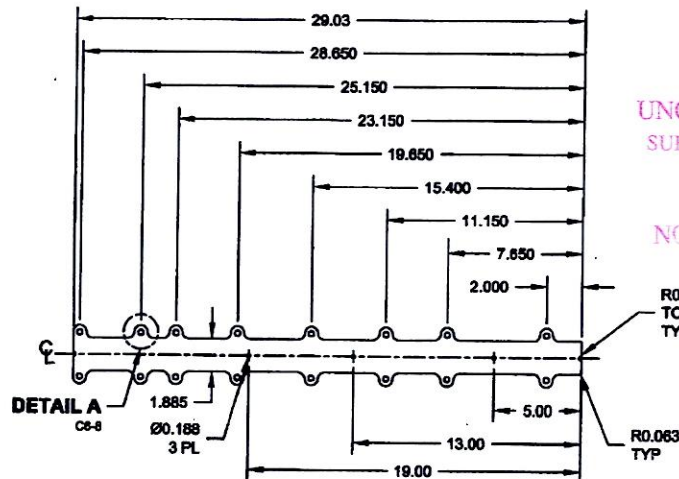
m137980

8.38

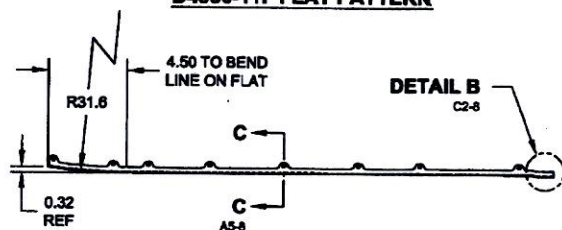
m138175

65.28

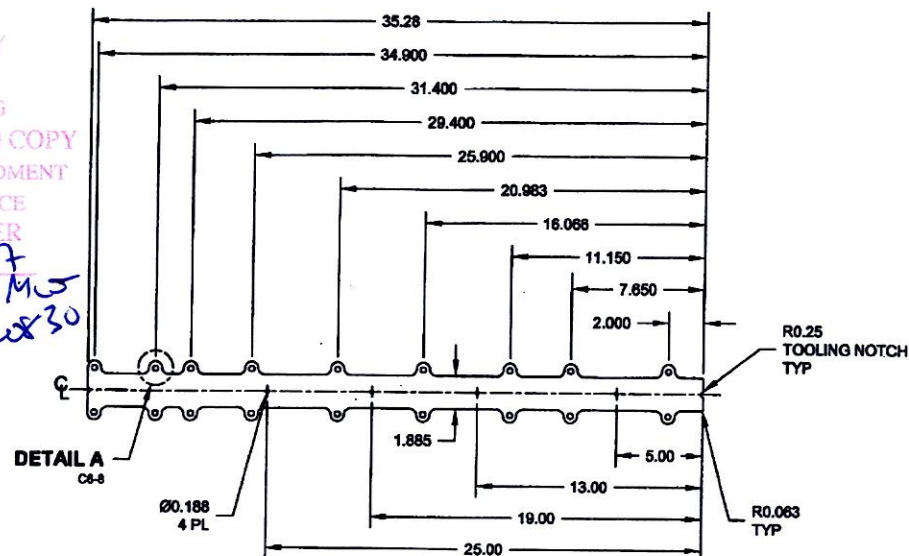
8.5



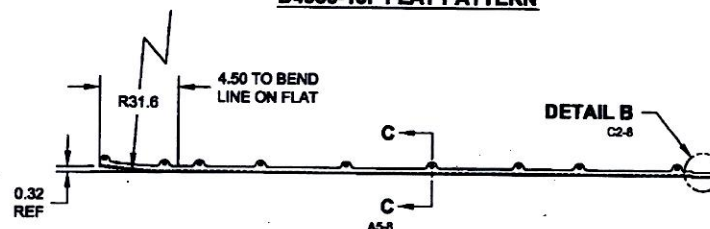
D4956-11F FLAT PATTERN



D4956-11 WEARSHOE
(MAKE FROM D4956-11F)



D4956-13F FLAT PATTERN



D4956-13 WEARSHOE
(MAKE FROM D4956-13F)

NOTES

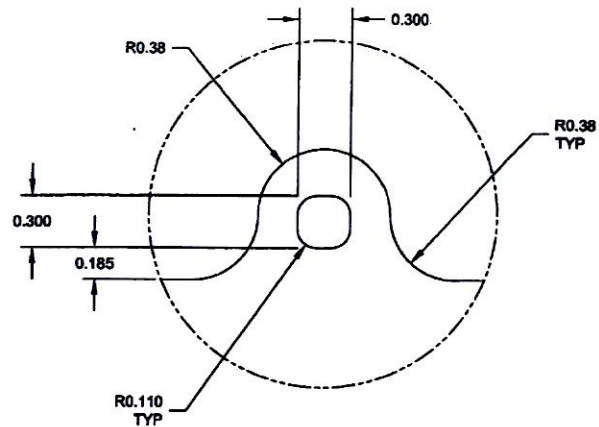
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-11 = 0.68 lbs; D4956-13 = 0.82 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165747
MJS
12x30

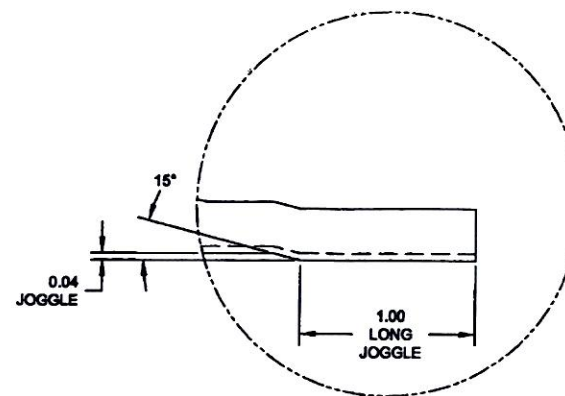
RELEASED
2014-04-17

REV.	DESCRIPTION	MB	13.09.26
DESIGN		BY	DATE
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.09.26		

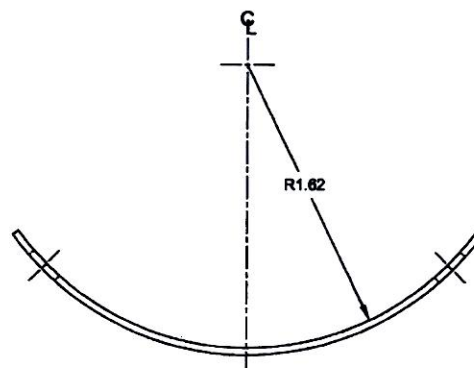
NEW ISSUE		MB	13.09.26
DESCRIPTION		BY	DATE
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. A	
D4956		SHEET 1 OF 8	
TITLE		SCALE	
WEARSHOE		NTS	
COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



DETAIL A C8-1 C4-1
C8-2 C1-3
C8-3 C1-3
C2-4 C2-6
C8-6 C2-6
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2 B1-3
B2-4 B1-7



SECTION C-C B7-1 B3-1
B5-2 B3-3
B6-4 B3-6
B7-6 B3-6
B7-7 B3-7

RELEASED
2014-04-17
JNP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.		D4956	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	13.09.26	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	